

Date: Wednesday, 1/11/2006 4:24:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B STEP ASSEMBLY RH
Job Number : 25447	
Estimate Number : 11115	
P.O. Number : N/A	Part Number : D206628012
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 2/5/2006
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	Qty: 3 Um: Each
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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(3)

Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-012 CHG 002

DA 06/02/24

2.0	25447A	206B STEP ASSY, RH
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Comment: Sub-Component D2721-042 SUB-ASSEMBLY
 206B STEP ASSY, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D27311	Mounting Lug
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-1 Mounting Lug

BKH652 ✓

5.0	D27317	Mounting Lug
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-7 Mounting Lug

B23331 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:24:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 25447

Part Number: D206628012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty	Part #	Description	Batch
2	D2856-400 6.9"	Abrasion Strip	B26041 ~

7.0	D2856400	Abrasion Strip
-----	----------	----------------



Comment: Qty.: 0.5460 f(s)/Unit Total : 1.6380 f(s)

Pick :

Qty	Part #	Description	Batch
2	D2856-400 6.25"	Abrasion Strip	B26041 ~

8.0	D3394041	LUG ASS'Y
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3394-041	LUG ASS,Y	B25407 ~

9.0	D3394043	LUG ASS'Y
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3394-043	LUG ASS,Y	B26185 ~

10.0	AN415A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-15A	Bolt	M19085 ~

11.0	AN411A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-11A	Bolt	M17771 ~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/04/18

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:24:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY RH

Job Number: 25447

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

M100273 ✓

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN960JD416

Washer

M100575 ✓

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21042L4

Nut (or MS21042-4)

M19099 ✓

18 06/04/11 (3)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

18 06/04/11 (3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-012

Location:

PPP Rev: R

18 06/04/11 (3)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

18 06/04/11 (3)

Job Completion



u 26.04.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:24:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206B STEP ASSY, RH
Job Number : 25447A	
Estimate Number : 11699	
P.O. Number : N/A	Part Number : D2721042
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : D2721 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 2/5/2006 Qty: 3 Um: Each
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	
Comment : Est Rev:F As Per Ecn 766 06-01-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>324563</u>

Check Material for any Dents or Defects

P.E. 06.03.21 3

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2721-2 using D2622 extrusion as per Dwg D2721
 Deburr and bevel ends for welding

P.E. 06.03.21 3

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>324402</u>

P.E. 06.03.21 3

4.0	D34611	PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

206 Step Lug

Pick:

Qty	Part Number	Description	Batch
1	D3461-1	Plate	<u>325211</u>

P.E. 06.03.21 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:24:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 25447A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-3	Plate	<u>325212</u>

HE 06.03.21 3

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-5	Plate	<u>325213</u>

HE 06.03.21 3

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-7	Plate	<u>325214</u>

HE 06.03.21 3

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod Batch: m18838

Grind end cap welds flush

HE 06.03.21 3

HE 06.03.22 3

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

HE 06.03.26 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:24:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 25447A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/04/01 (3)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 04 01 (3)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod Batch: M18838

SE 06.04.4

SE 06.04.4

SE 06.04.4

13.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-04-06 (3)
06/04/06 (3)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

JAD 06.04.08 (3)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/12 (3)

16.0

QC3


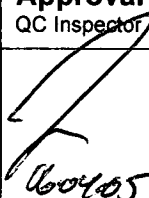
INSPECT POWDER COAT/CHEMICAL CONVERSION




Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 04 13 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.04.05	12.1	GRIND end cap welds flush	FF	06.04.05	3		 06.04.05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/04/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:24:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, RH

Job Number: 25447A

Part Number: D2721042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

FL 06 04 13 (3)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/13 (3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Handwritten signatures and initials

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SD 06/04/18 (3)

Job Completion



Handwritten signature and date 26-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

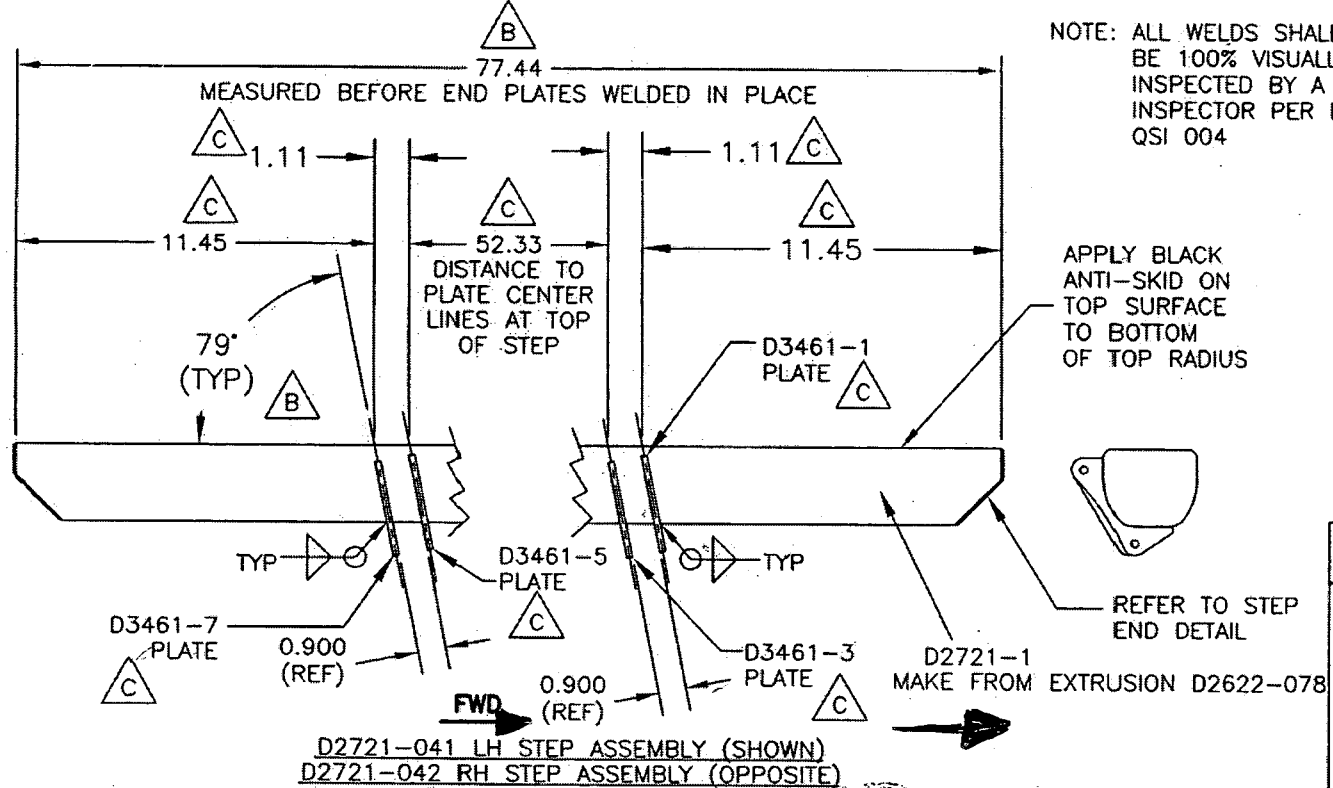
NOTE: Date & initial all entries

DART

RELEASED
05.11.14

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	05.09.19			
A		97.12.04		
B		98.10.19		
C		05.09.19		
TITLE	D2721	206B STEP ASSEMBLY		
NEW ISSUE				
REV. C				
SHEET 1 OF 1				
SCALE				
NTS				

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2721-041 LH STEP ASSEMBLY (SHOWN)
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

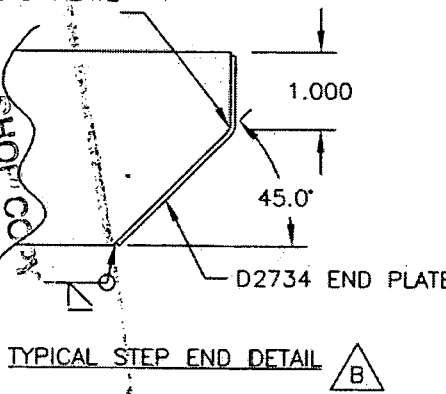
ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
X	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



WORK ORDER
NC25447A
SUBJECT TO
UNCONTROLLED
RETURN TO
ENGINEERING
SHOP CO.

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